

Date: Monday, 27/04/2009 7:32:36 AM
User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ROUND BILLET,,ALUMINUM
Job Number	: 47477		
Estimate Number	: 12286		
P.O. Number	:	Part Number	: D6103003
This Issue	: 27/04/2009 S.O. No. :	Drawing Number	: D6103 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 45034	Material	:
Written By	: _____	Due Date	: 08/05/2009 Qty: 30 Um: Each
Checked & Approved By	: <u>C207/04/27</u>		
Comment	: Est Rev:A New Issue 06-02-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 86501

a)Description: Alluminum round billet

b) Ø3.500" x 12.500" long t

c) Tolerance on all dimensions are $+0.030''/-0.000''$

d) Material: 7075-T7351 (QQ-A-225/9)

Material certification required

2.0	D6103003P	round alum billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)
alum billet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 7:32:36 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ROUND BILLET, ALUMINUM

Job Number: 47477

Part Number: D6103003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/11 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

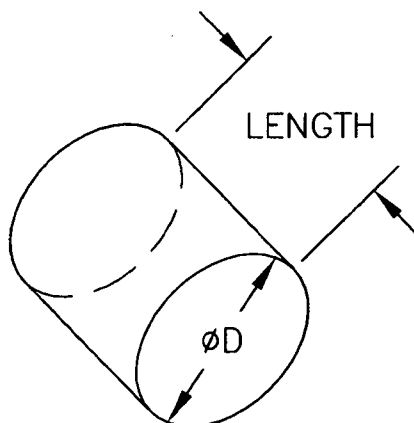
NOTE: Date & initial all entries



DESIGN P41	DRAWN BY P41	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

W/O: 47777

ALL DIMENSIONS ARE IN INCHES.

CLO 9/04/27

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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**Castle Metals®**

A. M. Castle & Co.

BORDEREAU DE MARCHANDISES

Page 1 of 1

No de Formulaire d'Emballage / Pack Slip No: 37432

Expédié de / Ship From: Castle Metals Montreal 835-Selkirk Avenue Pointe Claire, QUEBEC H9R 3S2		Vendu à / Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Expédié à / Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Livré à / Deliver To:	
Date d'expédition / Date Shipped	F.O.B.	Modalités de transport / Freight Terms		Transporteur / Carrier	N° du Bon de connaissance / BOL No	N° de livraison / Delivery No	
06-MAY-09	ORIGIN	Prepaid		Manitoulin	36108	2508866	

Détails d'expédition / Shipment Details	Destination finale / Final Destination Branch -
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N° de commande / Order No	N° de ligne / Line No	N° d'article / Item No	Description			
192409	1	8808.MO	3.5000.RD.7075.T7351.ALUMINUM.CF.132.0000-144.0000 CUT TO 12.5 IN ()			
N° de bon de commande / Purchase Order No		Nbre de pièces / Part Number	Qté commandée / Ordered Qty	Qté Facturée / Invoice Qty	Solde à livrer / Backorder Qty	
8650			33 PCS	33 PCS		
Détails / Details		No de coulee / Heat Number	Code mec / Mech Id	Pièces / PCS	Largeur (Pouce) / Width (IN)	Longueur (Pouce) / Length (IN)
Usine / Mill		20119217		33		Qté expédiée / Shipped Qty (LBS) 400.14

Ces marchandises/technologies sont sujettes aux règlements de l'Export Administration et du département d'État des États-Unis. Si elles ont été/sont exportées, elles doivent se conformer à ces règlements. Toute modification du contrat de transport contraire aux lois des États-Unis est interdite.

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

Nous certifions par la présente que le matériel couvert par cette certification est conforme aux spécifications susmentionnées et aux exigences applicables pour le matériel, y compris toute spécification faisant partie de la description. Les rapports d'essai sont archivés pour fins de consultation. Toute requête concernant du matériel défectueux sera rejetée à moins qu'elle ne soit faite par écrit à A. M. Castle & Co. dans les 60 jours suivant la livraison. Le matériel coupé sur mesure ou coupé par le client ne peut être retourné pour crédit.

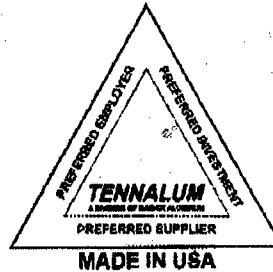
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Ce matériel a été reçu et inspecté par
This material has been received and inspected by:

Date:

KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://Certs.KaiserAluminum.com>

CUSTOMER PO NUMBER: 01-19802-1		CUSTOMER PART NUMBER: 8808		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 650601	LINE ITEM: 1	SHIP DATE: 04/06/2009	ALLOY: 7075	TEMPER: T7351	
WEIGHT SHIPPED: 1126 lbs.	QUANTITY: 8 pcs.	B/L NUMBER: 29298	DIAM/DAF/THKNS: 3.500 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA			SOLD TO: A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA		

Test Code: 1000 AC

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
20119217	70.8	59.6	15.0	39.1

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.13	0.27	1.4	0.04	2.7	0.19	5.9	0.02			20119217
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min			1.2		2.1	0.18	5.1				

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4124D, AMS-QQ-A-225/9 Non-Standard: A97075-11-9

04/05/09

CASTLE METALS CORP.
DATE RCVD 4-7-09
IAC 8808
APPROVED BY *Am*

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

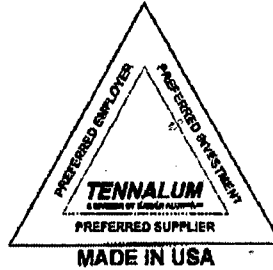
Plant Serial: 121047

Kaiser Order Number: 650601

KAISER ALUMINUM

FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://Certs.KaiserAluminum.com>

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES. Material complies with FAR BAA (FAR 52.225-1, Buy American Act-Supplies), DFARS BAA (DFARS 252.225-7001 Buy American Act & Bal of Payments Prog), and FAR TAA (FAR 52.225-5 Trade Agreements) AS9100B:2004 Material is RoHS compliant.

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

Plant Serial: 121047

Kaiser Order Number: 650601